

Work Order ID 84466

May-14-12 9:17:00 AM

84466

Boyle
ASD

Page 1

Item ID: D212-725-1-027

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: CO-PILOT #2 THROTTLE SPACER

Start Date: 14/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 28/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/14

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4218	A

100

0.00

100

CONVENTIONAL LATHE

12-05-16

Lathe Conv

Memo

0.00

Conventional Lathe

1-Turn as per Dwg
2-Deburr

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

12-05-16

QC

Memo

0.00

Quality Control

120

0.00

120

QC8- Inspect parts - second check

12-5-16

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84466

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Page 2

May-14-12 9:17:00 AM

Item ID: D212-725-1-027 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: CO-PILOT #2 THROTTLE SPACER
 Start Date: 14/05/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 28/05/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				1	76	12-5-16	
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				1	BA	12-5-16	
150 *150* Packaging Packaging	Identify as per dwg & Stock Location <i>SMP</i> Memo <i>RAG 1/2</i>	0.00 0.00						145/16	①

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 84466***84466***

Page 3

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Item ID: D212-725-1-027

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: CO-PILOT #2 THROTTLE SPACER

Start Date: 14/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 28/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC21 - Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MLJ 12/05/16
mf
12-05-16

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

May-14-12 9:17:04 AM

Page 1

Work Order ID: 84466

84466

Parent Item: D212-725-1-027

D212-725-1-027

Parent Item Name: CO-PILOT #2 THROTTLE SPACER

Start Date: 14/05/2012

Required Date: 28/05/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A New Issue 07-10-02 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T1.500W.125		Purchased	No			100	f	34.5000	0.315	0.331579			

M6061T6T1 500W 125

6061T6 RD TUBE 1.50 X .125W

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT016	34.5	
106747	4.5	
108626	5	
109025	25	

97 12-05-12

W/O:		WORK ORDER CHANGES					
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

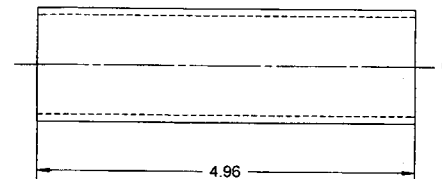
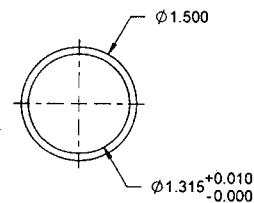
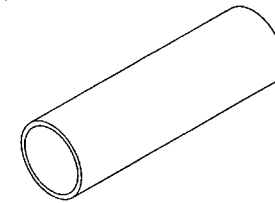
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NOTE: Date & initial all entries

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 84466 MLJ
12/05/14



D212-725-1-025 SPACER

RELEASED
 2011-08-25

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING
 PER WW-T-700/6 OR AMS 4080 OR AMS 4082
 OR QQ-A-200/8 OR QQ-A-225/8
 REF DART SPEC. M6061T6T OR M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.20 lbs

A		NEW ISSUE		RF	11.02.24
REV.		DESCRIPTION		BY	DATE
DESIGN	DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A SHEET 1 OF 2	
DRAWN	RF				
CHECKED	<i>[Signature]</i>	DRAWING NO.		SCALE	
MFG. APPR.	<i>[Signature]</i>	D4218		NTS	
APPROVED	<i>[Signature]</i>	TITLE			
DE APPR.	<i>[Signature]</i>	SPACER			
DATE	11.02.24	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

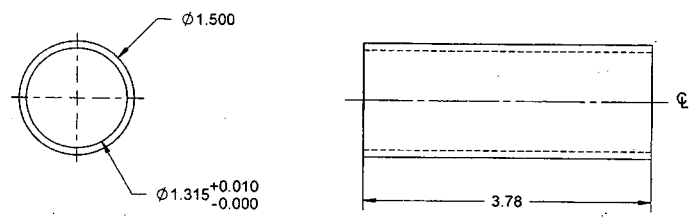
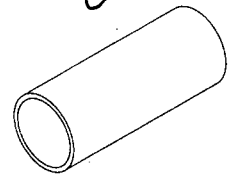
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NOTE: Date & initial all entries

24466



D212-725-1-027 SPACER

RELEASED
2011-08-25
MAY

- NOTES:**
- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
REF DART SPEC. M6061T6T OR M6061T6R
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.15 lbs

DESIGN	DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4218	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 2	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACER	NTS
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